

Work Order ID 128190

Monday, January 12, 2015 10:52:52 AM

128190

Page 1

Item ID: 649.4901

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Cutter Assy

Start Date: 1/12/2015 Start Qty: 5.00

5 3
5

Cust Item ID:

Required Date: 1/12/2015 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 15-01-12

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
649.4900	A								
110	Pick Kit	0.00							DAS 41 9-89
110						3			15-1-12
Packaging	Memo	0.00							
Packaging									
120		0.00							DAS 41 9-89
120						3			15-1-12
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg Assemble as per dwg Apply RTV TO ALL FAYING SURFACES RTV 598 BATCH: <u>125637</u> exp: <u>5/15</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
130						3			
QC	Memo	0.00							
Quality Control									

JAN 13 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Monday, January 12, 2015 10:52:52 AM

128190

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Upper Cutter Assy

Start Date: 1/12/2015 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 1/12/2015 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NB2***

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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Accept Qty	Reject Qty	Reject Number	Insp. Stamp

140

Identify as per dwg & Stock Location: CRKS 0.00

0.00

140

Packaging

Memo

0.00

Packaging

***IDENTIFY AS DWG PER APICAL MPP-120 BY LASER ETCH THE P#
AND REV***

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

3 _____ CR 15.01.13

MLS 15-01-14

mf
15-1-13

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Monday, January 12, 2015 10:52:55 AM

Page 1

Work Order ID: 128190

128190

Parent Item: 649.4901

649 4901

Parent Item Name: Upper Cutter Assy

Start Date: 1/12/2015

Required Date: 1/12/2015

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
649.8301 *649 8301* Cutter Sub Assembly		Manufactured	No			110	Each	3.0000	1	5		DAS 41 9-89	15-1-12
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				3					
				127694				3		3			
649.5311 *649 5311* Upper Deflector		Manufactured	No			110	Each	7.0000	1	4		DAS 41 9-89	15-1-12
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MF				7					
				108716				7		3			
MS27039-08-19 *MS27039-08-19* Screw		Purchased	No			110	Each	104.0000	3	13		DAS 41 9-89	15-1-12
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST273A				104					
				M130505				104		9			
NAS1149FN832P *NAS1149FN832P* Washer		Purchased	No			110	Each	5,082.000	6	30		DAS 41 9-89	15-1-12
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST260a				3600					
				125268				3600					
				st268				1482					
				M130388				1482		18			

DQA: _____ Date: _____



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Doc/Data									
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Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

Monday, January 12, 2015 10:52:55 AM

Page 2

Work Order ID: 128190

128190

Parent Item: 649.4901

649 4901

Parent Item Name: Upper Cutter Assy

Start Date: 1/12/2015

Required Date: 1/12/2015

Start Qty: 5.00

Required Qty: 5.00

MS21042L08

Purchased

No

110

Each

850.0000

3

~~15~~

DAS

41

9-89 15-1-12

MS21042L 08

Nut

Location

Loc Qty

Loc Code

CA

101

m129682

101

ST304

749

123900

16

m128401

210

m130325

523

9

DQA: _____ Date: _____



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APICAL
INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 03526

SHEET 1 OF 1

DWG NO. 649.4900

REV: A

PREPARED BY S. COCHRAN

DATE: 05-29-12

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER ASSY

APPROVED BY:

ENGR

MFG

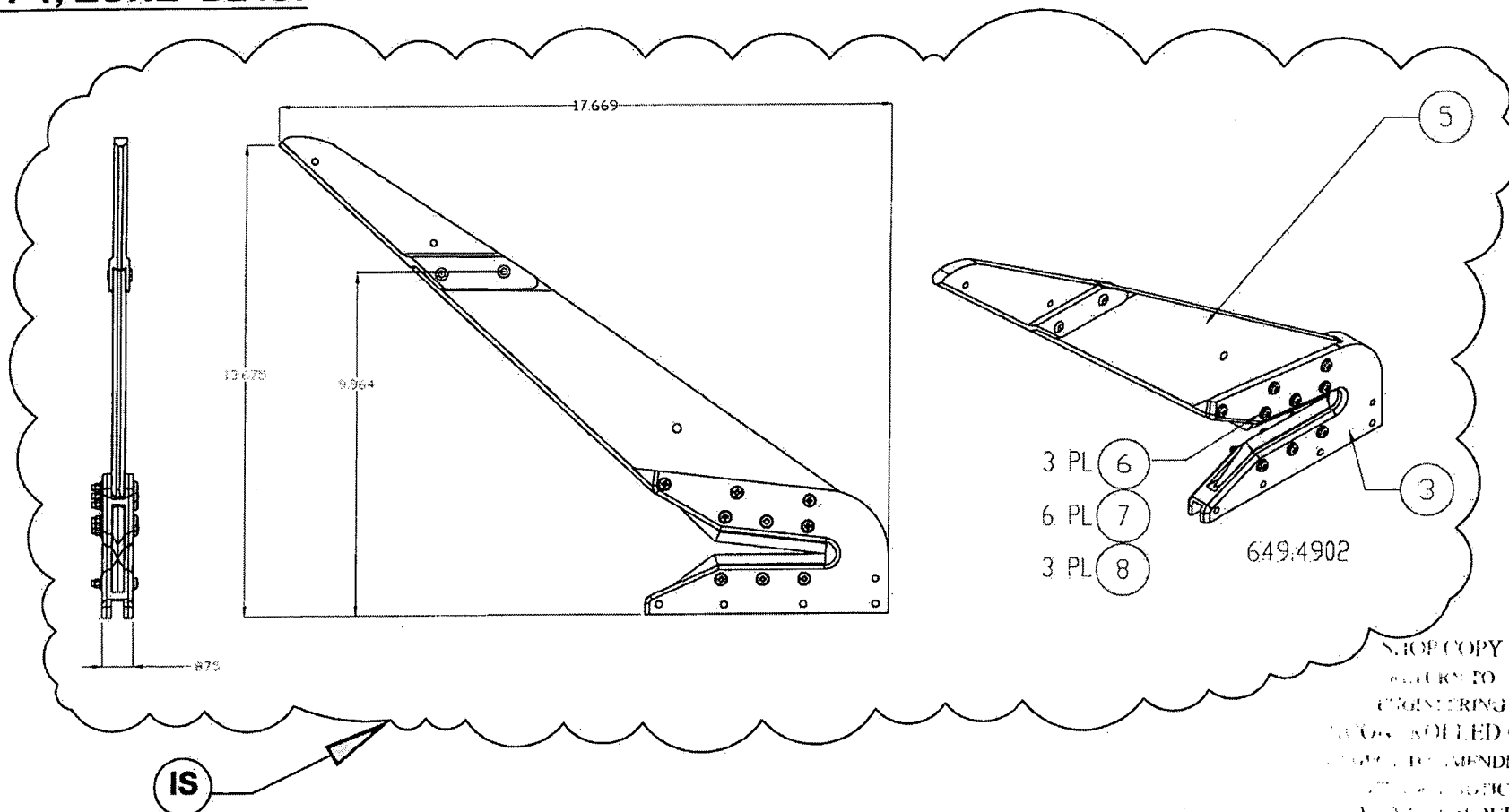
QC

EFF: CURRENT STOCK & NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: REVISED INSPECTION DIMENSIONS

SHEET 1, ZONE D2 IS:



3 PL 6
6 PL 7
3 PL 8

649.4902

STOP COPY
RETURN TO
ENGINEERING
FOR A ROLLED COPY
FOR THE AMENDMENT
PROCESS
YOUR ORDER
12-8-19-0-MCS
15-01-12

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

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FAULT CATEGORY

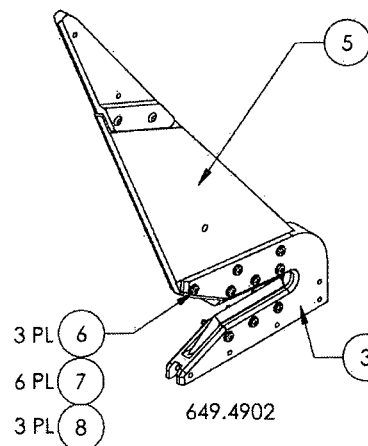
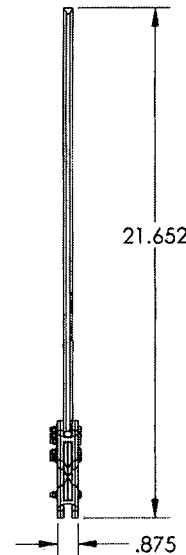
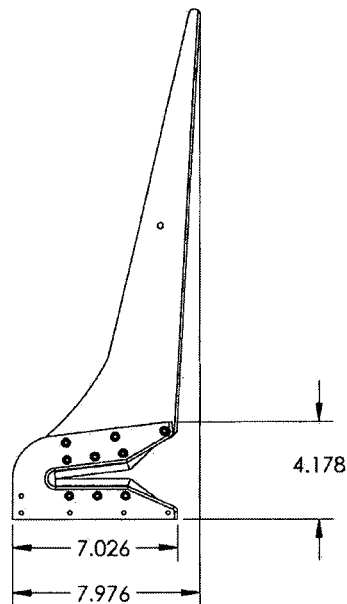
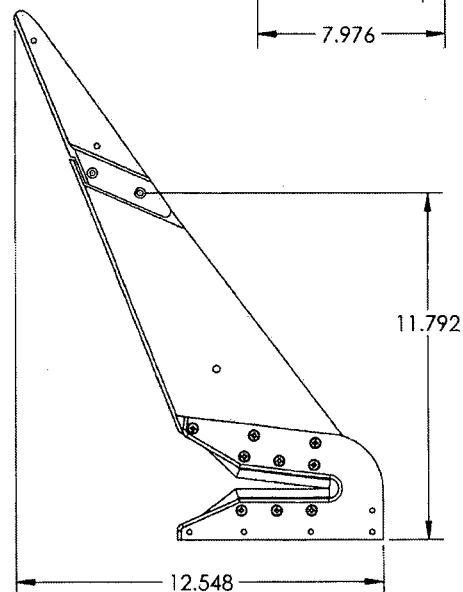
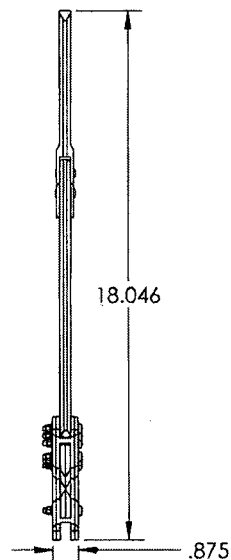
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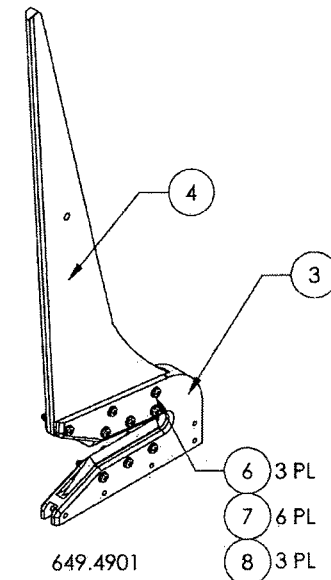
1. IDENTIFY IAW MPP-120.

UNINCORPORATED ECN(S)

03526



REVISIONS		
REV.	DESCRIPTION	DATE
1	LAST PROTOTYPE REVISIONS: PPS	N/A
2	INITIAL RELEASE	12-07-11
3	INCORPORATED ECNS 03487 & 03495	04-17-2012



3	3	8	601.1541	LOCKNUT	MS21042L08
6	6	7	601.2764	WASHER	NAS1149FN832P
3	3	6	601.2765	SCREW	MS27039-0819
1		5	649.5301	LOWER DEFLECTOR ASSY	
	1	4	649.5311	UPPER DEFLECTOR	
1	1	3	649.8301	CUTTER SUB ASSY	
		2	649.4902	LOWER CUTTER ASSY	
		1	649.4901	UPPER CUTTER ASSY	

QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
3	3	8	601.1541	LOCKNUT	MS21042L08
6	6	7	601.2764	WASHER	NAS1149FN832P
3	3	6	601.2765	SCREW	MS27039-0819
1		5	649.5301	LOWER DEFLECTOR ASSY	
	1	4	649.5311	UPPER DEFLECTOR	
1	1	3	649.8301	CUTTER SUB ASSY	
		2	649.4902	LOWER CUTTER ASSY	
		1	649.4901	UPPER CUTTER ASSY	

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

CUTTER ASSY

649.4900

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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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